



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

**D3573-3**  
**Job Sheet 194655**



Part No: D3573-3

Job Qty: 8 pcs

Part Name: Adapter



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/7/19

Job Tracking No:

Due Date: 5/27/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP Rev:A New Issue 07-01-29 JLM

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation         | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Lead Time | Sign-off |
|-------|-------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|-----------|----------|
|       |                   |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |           |          |
| 100   | Bandsaw - 1       | 8 pcs |            | 5/27/19  | 0.00      | 0.67    | Bandsaw - 1           | 32        | 19/05/13  |          |
| 110   | HAAS 4 Axis - B4B | 8 pcs |            | 5/27/19  | 0.29      | 8.70    | HAAS - 1 - B4B        | 52        | 19/05/13  |          |
|       |                   |       |            |          |           |         | HAAS - 2 - B4B        | 9-89      |           |          |
|       |                   |       |            |          |           |         | HAAS - 3 - B4B        |           |           |          |
|       |                   |       |            |          |           |         | HAAS - 4 - B4B        |           |           |          |
| 120   | QC 2              | 8 pcs |            | 5/27/19  | 0.00      | 0.00    | QC 2 - 1              |           |           |          |
|       |                   |       |            |          |           |         | QC 2 - 12             |           |           |          |
|       |                   |       |            |          |           |         | QC 2 - 14             |           |           |          |
|       |                   |       |            |          |           |         | QC 2 - 17             |           |           |          |
|       |                   |       |            |          |           |         | QC 2 - 19             |           |           |          |
|       |                   |       |            |          |           |         | QC 2 - 2              |           |           |          |
|       |                   |       |            |          |           |         | QC 2 - 20             |           |           |          |
|       |                   |       |            |          |           |         | QC 2 - 22             |           |           |          |
|       |                   |       |            |          |           |         | QC 2 - 23             |           |           |          |
|       |                   |       |            |          |           |         | QC 2 - 25             |           |           |          |
|       |                   |       |            |          |           |         | QC 2 - 32             |           |           |          |
|       |                   |       |            |          |           |         | QC 2 - 33             |           |           |          |
|       |                   |       |            |          |           |         | QC 2 - 35             |           |           |          |
|       |                   |       |            |          |           |         | QC 2 - 39             |           |           |          |
|       |                   |       |            |          |           |         | QC 2 - 4              |           |           |          |
|       |                   |       |            |          |           |         | QC 2 - 40             |           |           |          |
|       |                   |       |            |          |           |         | QC 2 - 44             |           |           |          |
|       |                   |       |            |          |           |         | QC 2 - 45             |           |           |          |
|       |                   |       |            |          |           |         | QC 2 - 48             |           |           |          |
|       |                   |       |            |          |           |         | QC 2 - 49             |           |           |          |
|       |                   |       |            |          |           |         | QC 2 - 50             |           |           |          |
|       |                   |       |            |          |           |         | QC 2 - 51             |           |           |          |
|       |                   |       |            |          |           |         | QC 2 - 52             |           |           |          |
|       |                   |       |            |          |           |         | QC 2 - 57             |           |           |          |
|       |                   |       |            |          |           |         | QC 2 - 62             |           |           |          |



Container No: S180463



Part: D3573-3

Job No: 194655

Serial No/Batch: S180463

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.  
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CANADA  
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Date: 05/13/19

Plex 5/7/19 8:50 AM Dart.lajeunesse.marie

NCL: 19-7234

|                                    |          |         |           |                           |              |
|------------------------------------|----------|---------|-----------|---------------------------|--------------|
| 130 QC 8                           | 8<br>pcs | 5/27/19 | 0.00 0.00 | QC 2 - 63                 |              |
|                                    |          |         |           | QC 2 - 8                  |              |
|                                    |          |         |           | QC 2 - 66                 |              |
|                                    |          |         |           | QC 2 - 64                 |              |
|                                    |          |         |           | QC 2 - 65                 |              |
|                                    |          |         |           | QC 2 - 5                  |              |
|                                    |          |         |           | QC 2 - 71                 |              |
|                                    |          |         |           | QC 8 - 12                 |              |
|                                    |          |         |           | QC 8 - 14                 | Fm 19/05/13  |
|                                    |          |         |           | QC 8 - 17                 |              |
|                                    |          |         |           | QC 8 - 20                 |              |
|                                    |          |         |           | QC 8 - 25                 |              |
|                                    |          |         |           | QC 8 - 3                  |              |
|                                    |          |         |           | QC 8 - 32                 |              |
|                                    |          |         |           | QC 8 - 33                 |              |
|                                    |          |         |           | QC 8 - 35                 |              |
|                                    |          |         |           | QC 8 - 39                 |              |
|                                    |          |         |           | QC 8 - 4                  |              |
|                                    |          |         |           | QC 8 - 44                 |              |
|                                    |          |         |           | QC 8 - 45                 |              |
|                                    |          |         |           | QC 8 - 49                 |              |
|                                    |          |         |           | QC 8 - 58                 |              |
|                                    |          |         |           | QC 8 - 8                  |              |
|                                    |          |         |           | QC 8 - 9                  |              |
|                                    |          |         |           | QC 8 - 68                 |              |
|                                    |          |         |           | QC 8 - 67                 |              |
|                                    |          |         |           | QC 8 - 1 (A)              |              |
|                                    |          |         |           | QC 8 - 47                 |              |
|                                    |          |         |           | QC 8 - 40                 |              |
|                                    |          |         |           | QC 8 - 52                 |              |
|                                    |          |         |           | QC 8 - 23                 |              |
| 140 Handfinish - 1-1 Chemical- B4B | 8<br>pcs | 5/27/19 | 0.00 1.38 | Handfinish - 1 - 1 - B4B  |              |
|                                    |          |         |           | Handfinish - 1 - 2 - B4B  |              |
|                                    |          |         |           | Handfinish - 1 - 3 - B4B  |              |
|                                    |          |         |           | Handfinish - 1 - 4 - B4B  |              |
|                                    |          |         |           | Handfinish - 1 - 5 - B4B  |              |
|                                    |          |         |           | Handfinish - 1 - 6 - B4B  |              |
|                                    |          |         |           | Handfinish - 1 - 7 - B4B  |              |
|                                    |          |         |           | Handfinish - 1 - 8 - B4B  |              |
|                                    |          |         |           | Handfinish - 1 - 9 - B4B  |              |
|                                    |          |         |           | Handfinish - 1 - 10 - B4B | D.R 19/05/13 |
|                                    |          |         |           | Handfinish - 1 - 11 - B4B |              |
|                                    |          |         |           | Handfinish - 1 - 12 - B4B |              |
|                                    |          |         |           | Handfinish - 1 - 13 - B4B |              |
|                                    |          |         |           | Handfinish - 1 - 14 - B4B |              |
|                                    |          |         |           | Handfinish - 1 - 15 - B4B |              |
|                                    |          |         |           | Handfinish - 1 - 16 - B4B |              |
|                                    |          |         |           | Handfinish - 1 - 17 - B4B |              |
|                                    |          |         |           | Handfinish - 1 - 18 - B4B |              |
|                                    |          |         |           | Handfinish - 1 - 19 - B4B |              |
|                                    |          |         |           | Handfinish - 1 - 20 -     |              |

|                                    |       |         |           |                           |  |
|------------------------------------|-------|---------|-----------|---------------------------|--|
|                                    |       |         |           | B4B                       |  |
|                                    |       |         |           | Handfinish - 1 - 21 - B4B |  |
|                                    |       |         |           | Handfinish - 1 - 22 - B4B |  |
| 150 Powdercoat - 3 Grey Sand - B4B | 8 pcs | 5/27/19 | 0.00 0.40 | Powdercoat - 1 - B4B      |  |
|                                    |       |         |           | Powdercoat - 2 - B4B      |  |
|                                    |       |         |           | Powdercoat - 3 - B4B      |  |
|                                    |       |         |           | Powdercoat - 4 - B4B      |  |
| 160 QC 3                           | 8 pcs | 5/27/19 | 0.00 0.00 | QC 3 - 10                 |  |
|                                    |       |         |           | QC 3 - 13                 |  |
|                                    |       |         |           | QC 3 - 15                 |  |
|                                    |       |         |           | QC 3 - 17                 |  |
|                                    |       |         |           | QC 3 - 18                 |  |
|                                    |       |         |           | QC 3 - 2                  |  |
|                                    |       |         |           | QC 3 - 28                 |  |
|                                    |       |         |           | QC 3 - 3                  |  |
|                                    |       |         |           | QC 3 - 30                 |  |
|                                    |       |         |           | QC 3 - 34                 |  |
|                                    |       |         |           | QC 3 - 36                 |  |
|                                    |       |         |           | QC 3 - 41                 |  |
|                                    |       |         |           | QC 3 - 51                 |  |
|                                    |       |         |           | QC 3 - 58                 |  |
|                                    |       |         |           | QC 3 - 59                 |  |
|                                    |       |         |           | QC 3 - 68                 |  |
|                                    |       |         |           | QC 3 - 9                  |  |
|                                    |       |         |           | QC 3 - 40                 |  |
|                                    |       |         |           | QC 3 - 19                 |  |
|                                    |       |         |           | QC 3 - 43                 |  |
| 170 Packaging 3-1 - Stock - B4B    | 8 pcs | 5/27/19 | 0.00 0.00 | QC 3 - 24                 |  |
|                                    |       |         |           | Packaging 3 - 1 - B4B     |  |
|                                    |       |         |           | Packaging 3 - 2 - B4B     |  |
|                                    |       |         |           | Packaging 3 - 3 - B4B     |  |
|                                    |       |         |           | Packaging 3 - 4 - B4B     |  |
|                                    |       |         |           | Packaging 3 - 5 - B4B     |  |
|                                    |       |         |           | Packaging 3 - 6 - B4B     |  |
|                                    |       |         |           | Packaging 3 - 7 - B4B     |  |
|                                    |       |         |           | Packaging 3 - 8 - B4B     |  |
|                                    |       |         |           | Packaging 3 - 9 - B4B     |  |
|                                    |       |         |           | Packaging 3 - 10 - B4B    |  |
|                                    |       |         |           | Packaging 3 - 11 - B4B    |  |
|                                    |       |         |           | Packaging 3 - 12 - B4B    |  |
|                                    |       |         |           | Packaging 3 - 13 - B4B    |  |
|                                    |       |         |           | Packaging 3 - 14 - B4B    |  |
|                                    |       |         |           | Packaging 3 - 15 - B4B    |  |
|                                    |       |         |           | Packaging 3 - 16 - B4B    |  |
|                                    |       |         |           | Packaging 3 - 17 - B4B    |  |
|                                    |       |         |           | Packaging 3 - 18 - B4B    |  |
|                                    |       |         |           | Packaging 3 - 19 - B4B    |  |
|                                    |       |         |           | Packaging 3 - 20 - B4B    |  |
|                                    |       |         |           | Packaging 3 - 21 - B4B    |  |
|                                    |       |         |           | Packaging 3 - 22 - B4B    |  |
|                                    |       |         |           | Packaging 3 - 23 - B4B    |  |
|                                    |       |         |           | Packaging 3 - 24 - B4B    |  |
|                                    |       |         |           | Packaging 3 - 25 - B4B    |  |
|                                    |       |         |           | Packaging 3 - 26 - B4B    |  |
|                                    |       |         |           | Packaging 3 - 27 - B4B    |  |
|                                    |       |         |           | Packaging 3 - 28 - B4B    |  |
|                                    |       |         |           | Packaging 3 - 29 - B4B    |  |

SK 19-5-15

M 138839  
START: 11:45 O.T. 3:00 FINISH: 12:15

DAS  
MAY 15 2019 40  
9-89

GARL MAY 16 2019

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                         |                     |                 |                        |      |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------|---------------------|-----------------|------------------------|------|
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                         |                     |                 | Packaging 3 - 30 - B4B |      |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                         |                     |                 | Packaging 3 - 31 - B4B |      |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                         |                     |                 | Packaging 3 - 32 - B4B |      |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                         |                     |                 | Packaging 3 - 33 - B4B |      |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                         |                     |                 | Packaging 3 - 34 - B4B |      |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                         |                     |                 | Packaging 3 - 35 - B4B |      |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                         |                     |                 | Packaging 3 - 36 - B4B |      |
| 180 QC 21 - SA                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | 8<br>pcs                | 5/27/19             | 0.00 0.00       | QC 21 - SA - 21        | DAS  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                         |                     |                 | QC 21 - SA - 70        | 21   |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                         |                     |                 | QC 21 - SA - 53        | 9-25 |
| MAY 17 2019                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                         |                     |                 |                        |      |
| Part Op 100 - Cut blank 3.500" long<br>Descriptions: 110 - (HAAS CNC Vertical Machine), Machine as per Folio FA673 and Dwg D3573<br>120 - (QC2- Inspect parts off machine FAI/FAIB)<br>130 - (QC8- Inspect parts - second check)<br>140 - (Chemical Conversion Coat per QSI005 4.1)<br>150 - (Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3), START TIME: _____<br>160 - (QC3- Inspect Part Finish)<br>170 - (Identify as per dwg & Stock Location: _____), LOCATION : GA<br>180 - (QC21- Final Inspection - Work Order Release) |                         |                     |                 |                        |      |
| Job BOM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                         |                     |                 |                        |      |
| Part / Item                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | Component Name          | Quantity            | Operation       | Container              |      |
| M6061T6B0.500X02.500                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | 6061-T6 Bar .500 X 2.50 | 2.3360 ft (.292 ea) | 100-Bandsaw - 1 | S174839                |      |
| Job Allocations                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                         |                     |                 |                        |      |
| Operation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | Component Part          | Required            | Inventory       | Allocated              |      |
| 100-Bandsaw - 1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | M6061T6B0.500X02.500    | 2                   | 21              | 0                      |      |
| Part Specifications                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                         |                     |                 |                        |      |
| Specifications could not be found.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                         |                     |                 |                        |      |

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|                              |  |              |         |
|------------------------------|--|--------------|---------|
| DART AEROSPACE LTD           |  | Work Order:  | 194655  |
| Description: Adapter         |  | Part Number: | D3573-3 |
| Inspection Dwg: D3573 Rev: A |  | Page 1 of 1  |         |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance     | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 3.31              | +/-0.030      | 3.311            | ✓      |        | Ver                  |          |
| 2.69              | +/-0.030      | 2.686            | ✓      |        | Ver                  |          |
| 2.31              | +/-0.030      | 2.310            | ✓      |        | Ver                  |          |
| 1.600             | +/-0.005      | 1.600            | ✓      |        | Ver                  |          |
| 0.36              | +/-0.030      | 0.356            | ✓      |        | Ver                  |          |
| 1.19              | +/-0.030      | 1.189            | ✓      |        | H.G.                 |          |
| 2.38              | +/-0.030      | 2.378            | ✓      |        | Ver                  |          |
| 1.420             | +/-0.010      | 1.419            | ✓      |        | Ver                  |          |
| 0.48              | +/-0.030      | 0.476            | ✓      |        | Ver                  |          |
| R0.63             | +/-0.030      | R.0.63           | ✓      |        | R.G.                 |          |
| R0.13             | +/-0.030      | R.0.13           | ✓      |        | R.G.                 |          |
| R0.02             | +/-0.030      | R.0.02           | ✓      |        | END MILL             |          |
| Ø0.209            | +0.005/-0.001 | Ø0.209           | ✓      |        | G.P.                 |          |
| Ø0.266            | +0.006/-0.001 | Ø0.266           | ✓      |        | G.P.                 |          |
| 0.390             | +0.010/-0.000 | 0.398            | ✓      |        | Mic                  |          |
| Ø0.675 x 0.190    | +/-0.010      | Ø.677x.189       | ✓      |        | Ver                  |          |
| Ø0.500 x 0.310    | +/-0.010      | Ø.500x.310       | ✓      |        | Ver                  |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |

|                                |                                                                                                 |                     |     |
|--------------------------------|-------------------------------------------------------------------------------------------------|---------------------|-----|
| Measured by: <sup>DAS</sup> 52 | Audited by:  | Prototype Approval: | N/A |
| Date: 19/05/13                 | Date: 19/05/13                                                                                  | Date:               | N/A |

| Rev | Date     | Change    | Revised by                                                                                   | Approved                                                                              |
|-----|----------|-----------|----------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------|
| A   | 07.04.04 | New Issue | KJ/JLM  |  |

**DART**  
AEROSPACE

## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

19-7234

Route update only

|                                                                                                                                                                                                                                                                                                                                                                           |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |  |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|
| Job: 194655                                                                                                                                                                                                                                                                                                                                                               |  | Part No. D357303                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |  |
| Date: 19/05/13                                                                                                                                                                                                                                                                                                                                                            |  | Sequence #: 210                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |  |
| DISPOSITION                                                                                                                                                                                                                                                                                                                                                               |  | DEPARTMENT/PROCESS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |
| Rework <input type="checkbox"/><br>Scrap <input checked="" type="checkbox"/><br>Use-as-is <input type="checkbox"/>                                                                                                                                                                                                                                                        |  | Cross tube <input type="checkbox"/><br>Small Fab <input type="checkbox"/><br>Finishing <input type="checkbox"/><br>Eng. (Non-AW) <input type="checkbox"/><br>Prod. Eng. Coord. <input type="checkbox"/><br>Rec/Store/Packaging <input type="checkbox"/><br>Engineering <input type="checkbox"/><br>Water Jet <input type="checkbox"/><br>Supplier <input type="checkbox"/><br>Quality <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                          |  | QTY Affected: 1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |  |
| Thickness is .002 under tolerance                                                                                                                                                                                                                                                                                                                                         |  | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |  |
| Thick and replace                                                                                                                                                                                                                                                                                                                                                         |  | Completed By: SC<br>19/05/13<br>Lead hand / Supervisor: [Signature]<br>19/05/13<br>QC / QA Coordinator: DAS 68<br>9-89 MAY 16 2019                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |
| Root Cause                                                                                                                                                                                                                                                                                                                                                                |  | FAULT CATEGORY                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |  |
| Operator <input checked="" type="checkbox"/><br>Manufacturing Process <input type="checkbox"/><br>Equip/Tooling <input type="checkbox"/><br>Handling/Preservation <input type="checkbox"/><br>Material <input type="checkbox"/><br>Product Improvement <input type="checkbox"/><br>Process Improvement <input type="checkbox"/><br>Human Factors <input type="checkbox"/> |  | Contamination <input type="checkbox"/><br>Misaligned/off center <input type="checkbox"/><br>BOM/Route <input type="checkbox"/><br>Broken/Damage/Defect <input type="checkbox"/><br>Incomplete/Unclear Instructions <input type="checkbox"/><br>Drill Holes <input type="checkbox"/><br>Fit/Function <input type="checkbox"/><br>Power Loss/Surge <input type="checkbox"/><br>Folio/Program <input type="checkbox"/><br>Grain Direction <input type="checkbox"/><br>Weld <input type="checkbox"/><br>Wrong Stock Pulled <input type="checkbox"/><br>Out of Sequence <input type="checkbox"/><br>Off-set/Set-up <input type="checkbox"/><br>Positioned Wrong <input type="checkbox"/><br>Outside Tolerance <input checked="" type="checkbox"/><br>Drawing <input type="checkbox"/><br>Finish <input type="checkbox"/><br>Part Lost/Missing <input type="checkbox"/><br>Misread <input type="checkbox"/> |  |
| Other/Details:                                                                                                                                                                                                                                                                                                                                                            |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |  |

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev J